

Work Order ID 54843

December 29, 2009 8:26:54 AM

Page 1

Item ID: D3293-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 12/30/2009 Start Qty: 10.00

Required Date: 1/13/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: CMF Date: 09-12-29 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3293 | Rev A |

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

10-1-6

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-1-6

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

278 10/11/06

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Item ID: D3293-1

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Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 12/30/2009 Start Qty: 10.00



Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130 | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1- Deburr | | | | | | | | |
| | <i>12/17</i> | | | | | | | | |
| 140 | QC5- Inspect part completeness to spec on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| | <i>25 10/6/06</i> | | | | | | | | |
| 150 | Chemical Conversion Coat per QS1005 4.1 | 0.00 | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| | <i>M 10/05/01</i> | | | | | | | | |
| | <i>(X10) 8</i> | | | | | | | | |

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NOTE: Date & initial all entries

Work Order ID 54843

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Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 12/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/07

MF 10-01-07

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:53 AM

Page 1

Work Order ID: 54843

Parent Item: D3293-1

Parent Item Name: Doubler

Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M2024T3S.080 | | Purchased | No | | | 100 | sf | 169.2618 | 19.2253 | | | |



2024-T3 .080 sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

169.26185

104921

3

105411

17

107460

4.36

110908

29.52205

112331

105.8798

15628

6

17695

1.5

18481

2

110394



B 10-1-6

10

112331 X 7

110394 X 3

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NOTE: Date & initial all entries

#54843

DART

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|---------|----------|-----------|---------|---|--------------|
| DESIGN | WIP | DRAWN BY | WIP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | APPROVED | | DRAWING NO. | D3293 |
| DATE | 04.06.28 | TITLE | DOUBLER | REV. A | SHEET 1 OF 1 |
| A | 04.06.28 | NEW ISSUE | | SCALE | 1:3 |

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

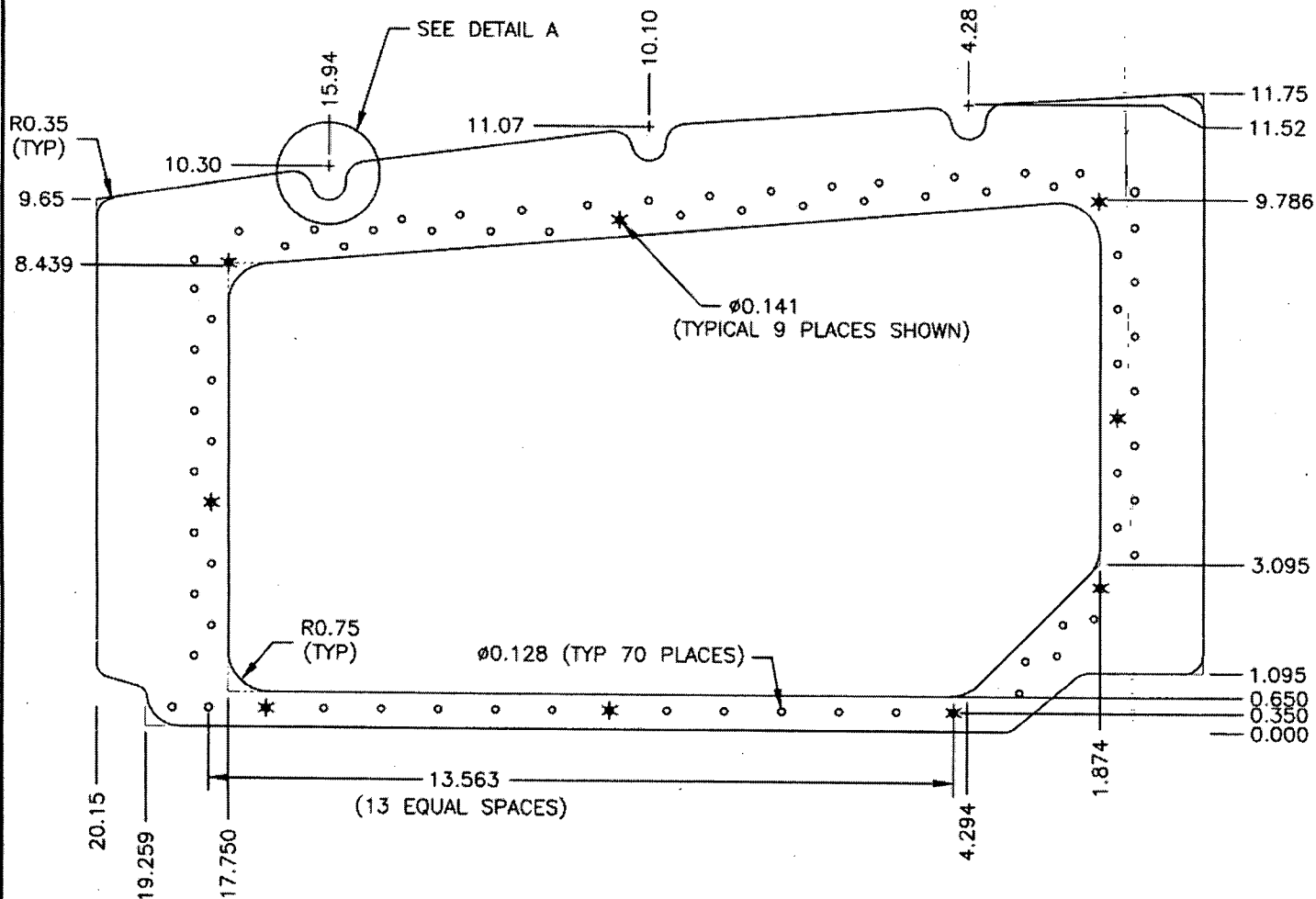
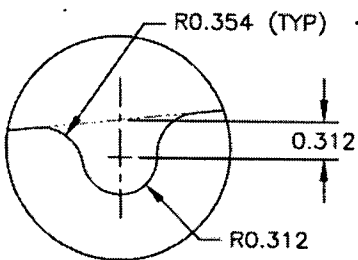
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

DETAIL A
SCALE 2:3

| W/O: | | WORK ORDER CHANGES | | | | | |
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